Work Order ID 126273

Tuesday, November 04, 2014 11:49:04 AM

126273

Item ID: D3022-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Seat Pan **Stop** *NS2*

Start Date: 11/4/2014 **Start Qty:** 1.00 *1*

Required Date: 11/4/2014 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 14-11-04 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D3022 / Rev B									
100	FLOW WATER JET	0.00							
100 Waterjet	**Memo**	0.00				1		Dc 14/11/20	
FLOW CNC Waterjet	1-Cut as per Dwg D3022 Dwg Rev: B Prog Rev: B *** grind direction along 31.700" *** **NO HOLES,TRANSFER DRILLED AT ASSEMBLY*** 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110 QC	**Memo**	0.00				1		Dc 14/11/20	
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Work Order ID 126273

Tuesday, November 04, 2014 11:49:04 AM

126273

Item ID: D3022-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Seat Pan

Start Date: 11/4/2014 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 11/4/2014 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				1			DAS 38 9-89 NOV 24 2014
120									
QC	**Memo**	0.00							
Quality Control									
130	Bend as per dwg	0.00		DAS 30 9-89		1			11/24/14
130									
Brake NC	**Memo**	0.00							
Brake NC									
140	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89 NOV 25 2014
140									
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
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FAULT CATEGORY

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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D3022-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Seat Pan

Start Date: 11/4/2014 **Start Qty:** 1.00 *1*
Required Date: 11/4/2014 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: WAGO	0.00							
200						1X		DAS 26 9-89	NOV 25 2014
Packaging	**Memo**	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210							14/12/2		
QC	**Memo**	0.00							
Quality Control									

MF
14-11-25

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Tuesday, November 04, 2014 11:49:07 AM

Work Order ID: 126273

126273

Parent Item: D3022-1

D3022-1

Parent Item Name: Seat Pan

Start Date: 11/4/2014 **Required Date:** 11/4/2014

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP C02.01.23Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC
IPP Rev:E 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	250.4310	1.6232	2			
M2024T3S.032									**				
2024-T3 .032 sheet													

Location		Loc Qty	Loc Code
MAT022		250.431	
	M130497	250.431	

14/11/20

4.DZ

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
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Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

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☐ Set-up
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☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	126273
Description: Seat Pan	Part Number:	D3022-1
Inspection Dwg: D3022 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.75	+/-0.030	14.75	✓		V-DL-02	
12.28	+/-0.030	12.28	✓		Tape	
2.72	+/-0.030	2.72	✓			
14.62	+/-0.030	14.62	✓			
12.15	+/-0.030	12.15	✓			

Measured by:	DA/EZ
Date:	14/11/24

Audited by:	DAS 38 9-89
Date:	14-11-24

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	08.06.13	New Issue	KJ/DD	
B	11.06.21	Dwg Rev updated	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

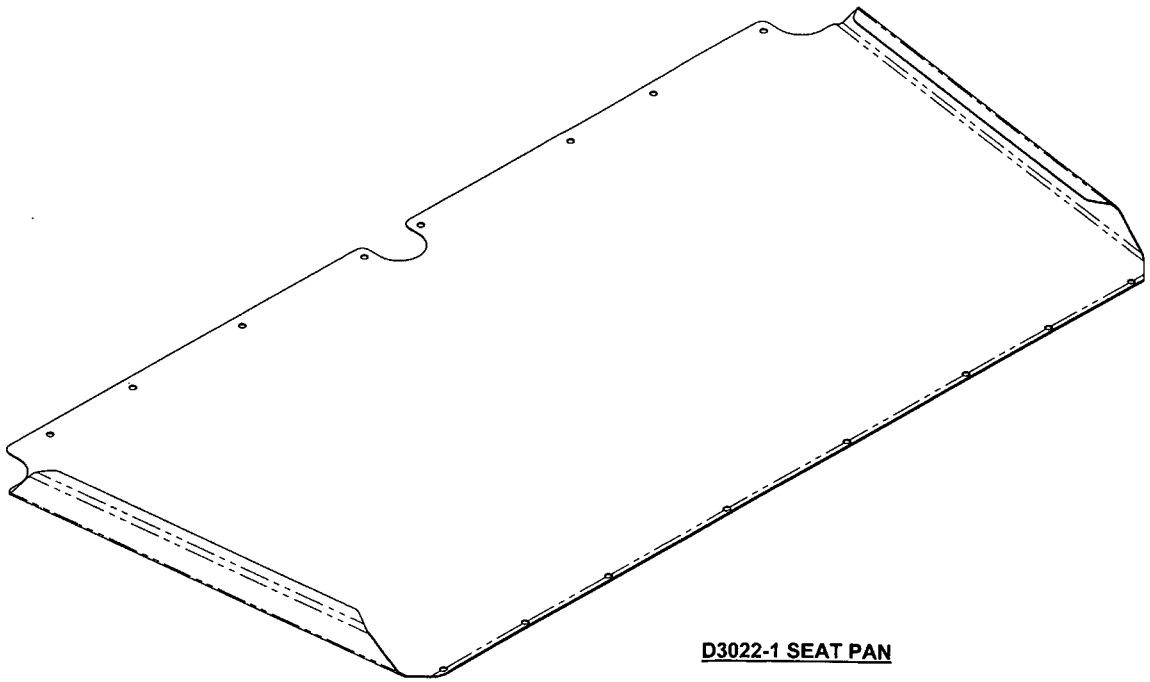
FAULT CATEGORY

Landing Gear

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General

☐ Bend
☐ BOM/Route
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



D3022-1 SEAT PAN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 126273 MLS
14-11-04

RELEASED
06/12/15 MW

REV.	DESCRIPTION	BY	DATE
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. B7-2 7° DIM ADDED, D7-3 12.075 WAS 12.325, D6-3 9.175 WAS 9.425 & D5-3 5.300 WAS 5.550. REASON: DRAFTING ERROR.	AJS	08.11.27
A	NEW ISSUE	CP	01.05.18

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3022	REV. B
MFG. APPR.			SHEET 1 OF 3
APPROVED		TITLE SEAT PAN	SCALE NTS
DE APPR.			
DATE	08.11.27		

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
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Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

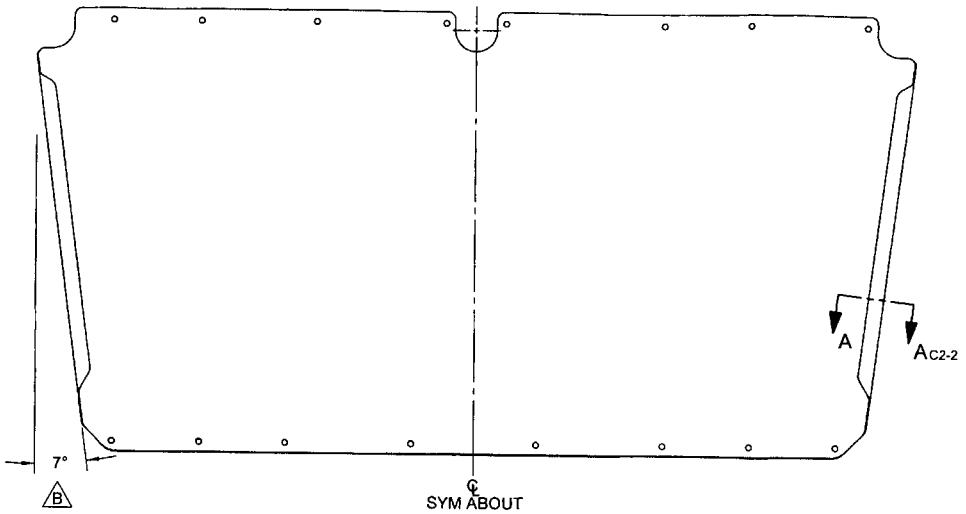
FAULT CATEGORY

Landing Gear

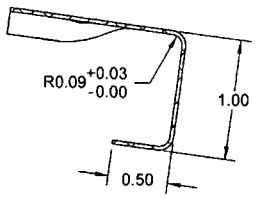
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☐ Cuffs
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☐ Inspection Strip in Tube
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General

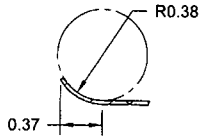
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☐ Weld
☐ Wrong Stock Pulled
☐ Other



D3022-1 SEAT PAN (B)



SECTION A-A C4-2
SCALE 4X



SECTION B-B A6-2
SCALE 4X

RELEASED
08/12/15

NOTES:
1) MATERIAL: MAKE FROM D3022-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.36 lbs

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3022 REV. B
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE SEAT PAN SCALE NTS
DE APPR.		
DATE	08.11.27	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Supplier	☐									
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Transport	☐									
Unapproved	☐									

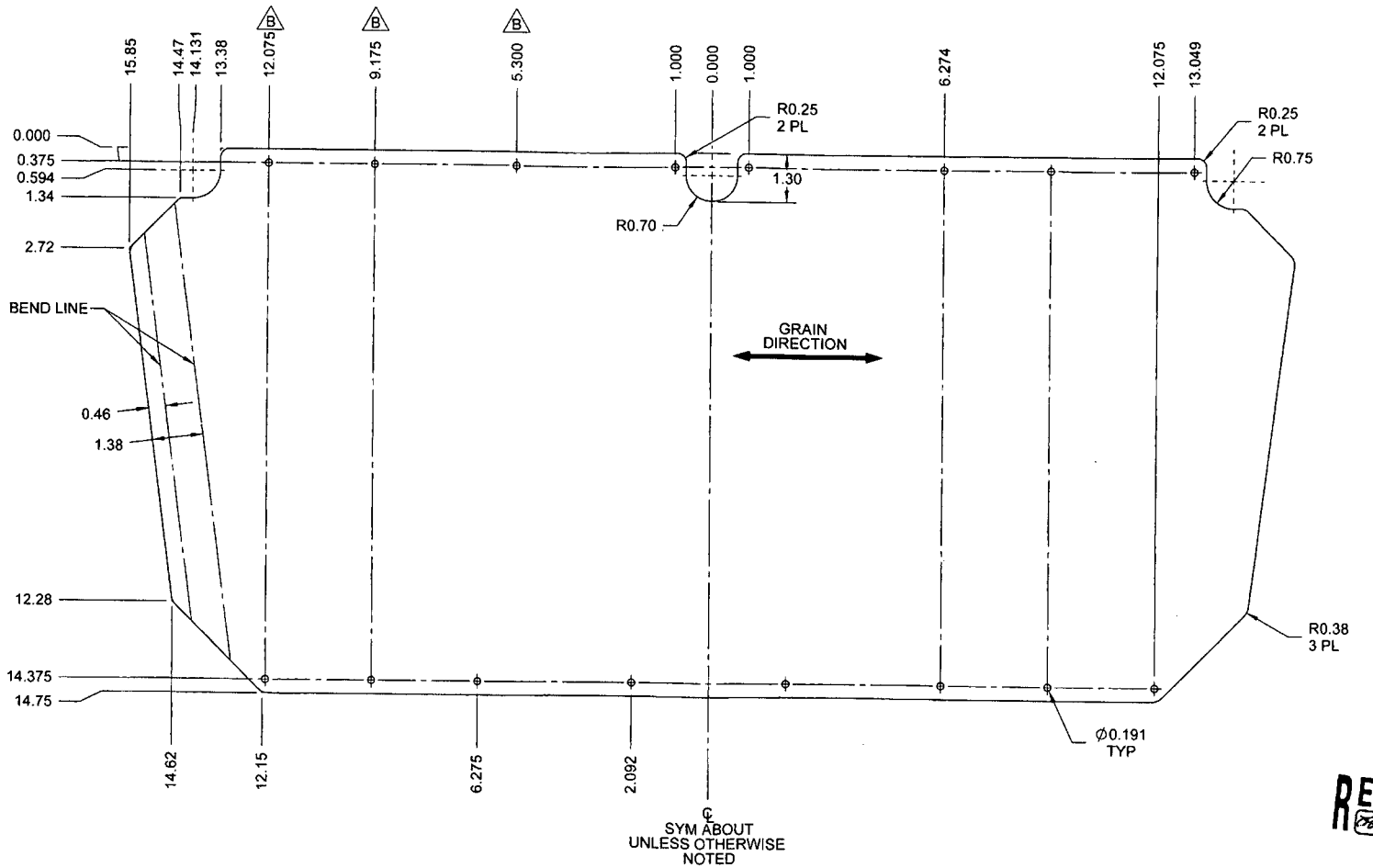
FAULT CATEGORY

Landing Gear

- ☐ Bending
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- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other



RELEASED
08/12/15 JM

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN (B)

DESIGN	CP	**DART AEROSPACE LTD**
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3022 REV. B
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE SEAT PAN SCALE NTS
DE APPR.		
DATE	08.11.27	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

